

Date: Monday, 3/13/2006 7:30:19 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 26211B		
Estimate Number	: 10378		
P.O. Number	: N/A	Part Number	: D30653
This Issue	: 3/13/2006 S.O. No. : N/A	Drawing Number	: D3065 REV. A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A2
Previous Run	: 24408B	Material	: N/A
Written By	: <u>SPK</u> <u>Comment Below</u>	Due Date	: 3/30/2006
Checked & Approved By	: <u>06.03.13</u>	Qty:	60 Um: Each
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.2287 sf(s)/Unit Total: 13.7214 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: 19295

ml 06 05 03 (64)

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 6.600" x 4.320" Grain along 4.320"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA180 and Dwg D3065

Stack of 15

Identify as D3065-3

water jet

ml 06 05 03 (64)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06 05 03 (64)

5.0	QC8	SECOND CHECK
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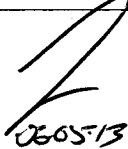
Comment: SECOND CHECK

06 05 13 (64) 59 PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/06/09

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-13	3	Sparks scrap. hole Damage due to waste Det. hole size good, <del>was</del> damage along outside of hole (crattered)		scrap: destroy.	 06-05-13	 06-05-13	 06-05-13	 06-05-13

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 7:30:19 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 26211B

Part Number: D30653

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

H.M 06/05/15 (59)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

SB 06/06/02 (59)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/06/02 x (59)

9.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF 06/06/05 (59)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 06/06/05 59

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

SB 06/06/05 59

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/05

Job Completion



u 06/06/05

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

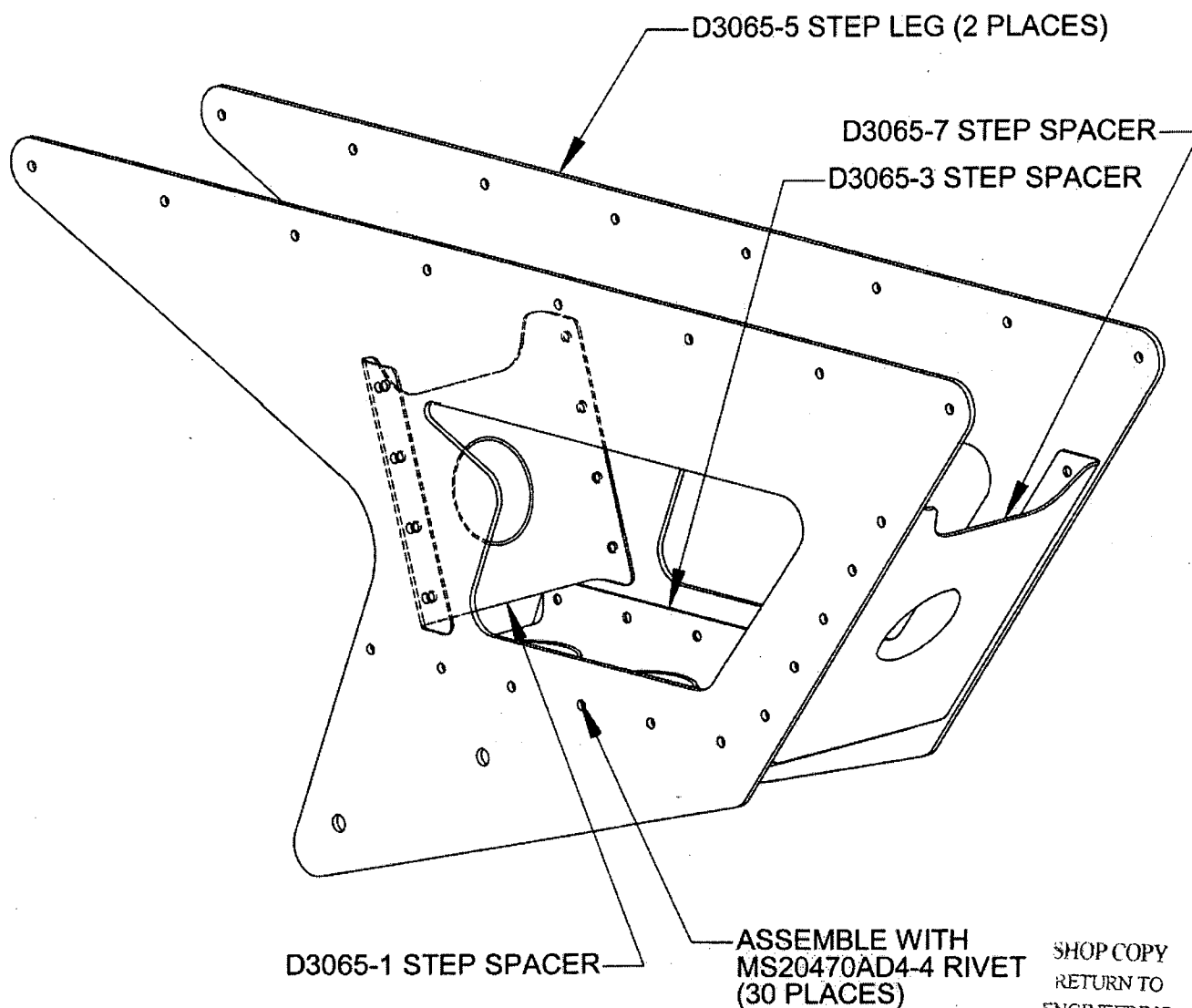
**NOTE:** Date & initial all entries





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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3065	REV. A SHEET 1 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
A1	03.02.13 <i>CP</i>	ADD SLOTS TO D3065-5	
A2	03.02.27 <i>CP</i>	0.551 WAS 0.410	

RELEASED  
02.09.20 *#*



## D3065-041 STEP LEG ASSEMBLY

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WITHOUT NOTICE  
WORK ORDER  
NO. *26211B*

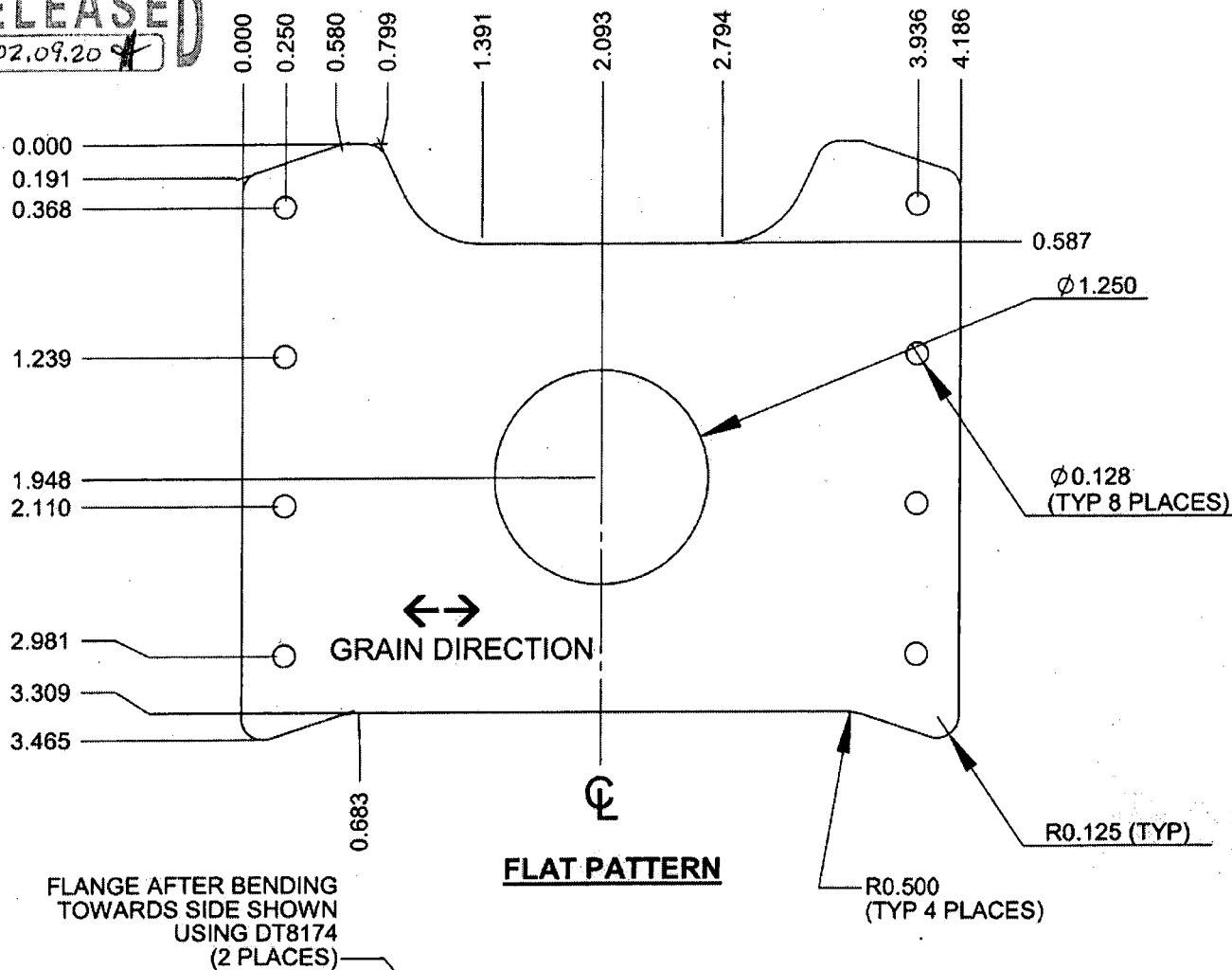
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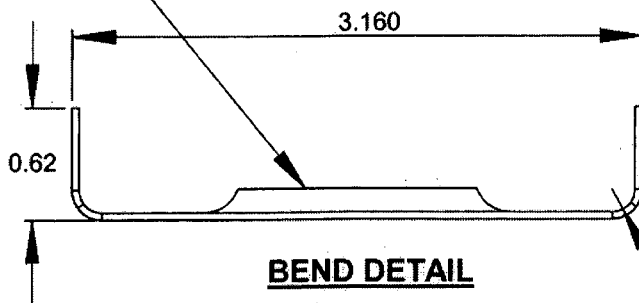
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. A SHEET 2 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED  
02.09.20



FLANGE AFTER BENDING  
TOWARDS SIDE SHOWN  
USING DT8174  
(2 PLACES)

**FLAT PATTERN**



**BEND DETAIL**

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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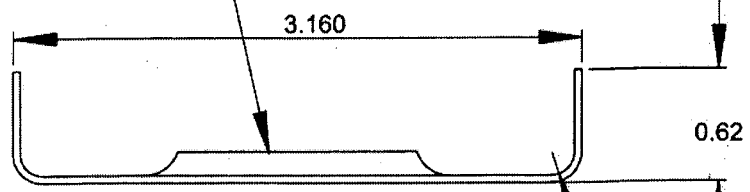
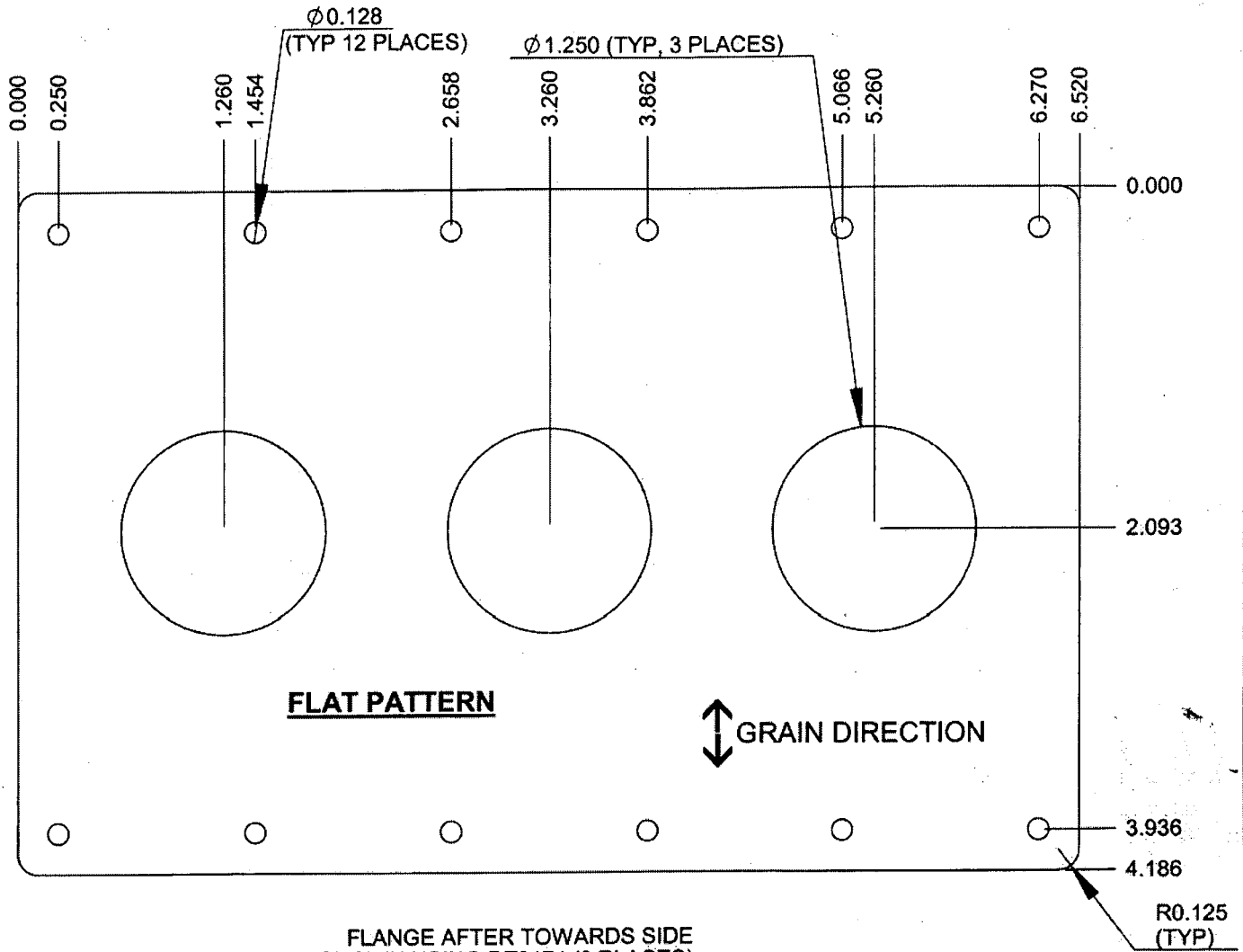
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02.09.20

**DART**



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CHECKED #	APPROVED #	DRAWING NO. <b>D3065</b>	REV. A SHEET 3 OF 5
DATE <b>02.09.11</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1



**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**BEND DETAIL**

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NO. 26211B

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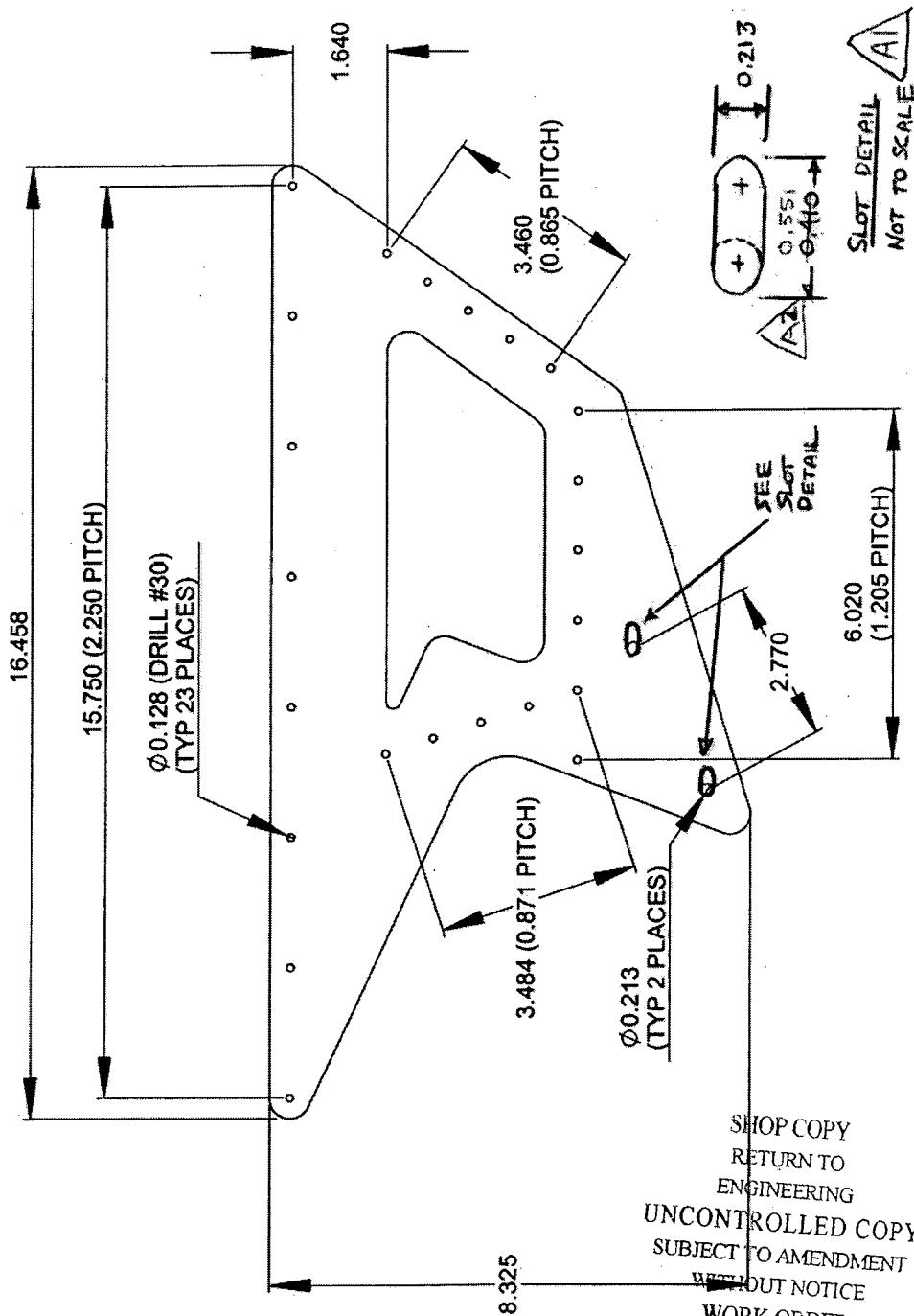
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CHECKED #	APPROVED #	DRAWING NO. D3065	REV. A SHEET 4 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:3

RELEASED  
02.09.20 #



- D3065-5 STEP LEG**
- 1) MACHINE PER DWG FILE "D3065-5.SLDPR1"
  - 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
  - 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
  - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
  - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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